



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D4294-1

Job Sheet 175296



Part No: D4294-1

Job Qty: 5 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/2/18

Job Tracking No:

Due Date: 4/13/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-11-25 JLM VERIFIED BY:DD IPP REV B: AS PER REV B 11-02-15
JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	4/12/18	4/12/18	0.00	0.00	Start Up Machining-2		
100	Bandsaw	5 pcs	4/12/18	4/12/18	0.00	0.36	Bandsaw1		
110	CNC Vertical Machining	5 pcs	4/12/18	4/12/18	0.46	14.29	HAAS 5 Axis		
120	QC	5 pcs	4/12/18	4/12/18	0.00	0.00	QC2 Machining-2		
130	QC	5 pcs	4/12/18	4/12/18	0.00	0.00	QC8 Machining-2		
140	HandFinish	5 pcs	4/12/18	4/12/18	0.00	0.31	HandFinish1		
145	Powdercoat	5 pcs	4/12/18	4/12/18	0.00	0.35	Powdercoat1		
150	QC	5 pcs	4/12/18	4/12/18	0.00	0.00	QC3		
151	Small Fab	5 pcs	4/13/18	4/13/18	0.00	0.24	Small Fab-6		
152	QC	5 pcs	4/13/18	4/13/18	0.00	0.00	QC5		
180	Packaging	5 pcs	4/13/18	4/13/18	0.00	0.00	Packaging3-2	5K33	
190	QC21-SA	5 Ea	4/13/18	4/13/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank to 7.125" ****GRAIN ALONG 4*****

Descriptions: 110 - 1-Machine per folio FB008

145 - MASK THREADED HOLE

151 - INSTALL HELICOIL AS PER DWG

M138760 START: 3:25. OUT: 3:50 FINISH 3:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T73B4.000x4.000	7075-T73 Bar 4.0 X 4.0 Grain Direction Along 4" Wide	3 ft (.6 ea)	90-Start up Operation	
MS21209F1-10	Heli Coil	5 Ea (1 ea)	151-Small Fab	

S059508

F7137951-5

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T73B4.000x4.000	3	44	0
151-Small Fab	MS21209F1-10	5	49	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.065Inches ± 0.010	0.075		

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DART
AEROSPACE

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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
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Container No: S060529



Part: D4294-1

Job No: 175296

Serial No/Batch: S060529

Revision:

Inspector:

Date: 04/12/18

			0.055	
2	Fitting	0.063Inches ± 0.010	0.073 0.053	Radius .063
3	Fitting	0.305Inches + 0.030 - 0.010	0.335 0.295	.305
4	Fitting	3.170Inches ± 0.030	3.200 3.140	3.175
5	Fitting	3.110Inches ± 0.030	3.140 3.080	3.110
6	Fitting	0.325Inches ± 0.010	0.335 0.315	.325
7	Fitting	0.780Inches ± 0.010	0.790 0.770	.783
8	Fitting	0.800Inches ± 0.030	0.830 0.770	.800
9	Fitting	1.560Inches ± 0.010	1.570 1.550	1.565
10	Fitting	0.500Inches ± 0.010	0.510 0.490	.500
11	Fitting	0.070Inches ± 0.010	0.080 0.060	.070
12	Fitting	0.390Inches ± 0.030	0.420 0.360	.398
13	Fitting	0.500Inches ± 0.010	0.510 0.490	.507
14	Fitting	0.880Inches ± 0.030	0.910 0.850	.874
15	Fitting	3.440Inches ± 0.030	3.470 3.410	3.440
16	Fitting	2.450Inches ± 0.010	2.460 2.440	2.450
17	Fitting	2.040Inches ± 0.030	2.070 2.010	2.042
18	Fitting	1.528Inches ± 0.010	1.538 1.518	1.528
19	Fitting	0.300Inches ± 0.010	0.310 0.290	.300
20	Fitting	0.738Inches ± 0.010	0.748 0.728	.734
21	Fitting	0.250Inches ± 0.030	0.280 0.220	.249
22	Fitting	3.375Inches ± 0.010	3.385 3.365	3.378
23	Fitting	4.8750Inches ± 0.0100	4.8850 4.8650	4.875
24	Fitting	1.670Inches ± 0.010	1.680 1.660	1.670
25	Fitting	0.386Inches + 0.006 - 0.001	0.392 0.385	.388
26	Fitting	0.266Inches + 0.006 - 0.001	0.272 0.265	.266
27	Fitting	6.810Inches ± 0.030	6.840 6.780	6.812
28	Fitting	6.350Inches ± 0.030	6.380 6.320	6.350
29	Fitting	1.460Inches ± 0.030	1.490 1.430	1.459
30	Fitting	0.050Inches ± 0.010	0.060 0.040	.050
31	Fitting	3.440Inches ± 0.010	3.450 3.430	3.440
32	Fitting	4.968Inches ± 0.010	4.978 4.958	4.968
33	Fitting	0.875Inches + 0.010 - 0.001	0.885 0.874	.875

4/2/2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle

34	Fitting	0.332Inches + 0.020 - 0.010	0.352 0.322	.332
35	Fitting	0.750Inches ± 0.010	0.760 0.740	.750
36	Fitting	6.490Inches ± 0.030	6.520 6.460	6.490
37	Fitting	0.691Inches ± 0.010	0.701 0.681	.691
38	Fitting	0.640Inches ± 0.030	0.670 0.610	.633
39	Fitting	0.201Inches + 0.005 - 0.001	0.206 0.200	.203
40	Fitting	0.320Inches ± 0.010	0.330 0.310	.325
41	Fitting	100Degrees ± 0	100 100	100°
42	Fitting	0.764Inches ± 0.010	0.774 0.754	.764
43	Fitting	0.381Inches + 0.000 - 0.001	0.381 0.380	.380
44	Fitting	1.405Inches ± 0.010	1.415 1.395	1.406
45	Fitting	1.125Inches ± 0.010	1.135 1.115	1.125

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